

Work Order ID 70686

Monday, June 13, 2011 1:32:06 PM



Page 1

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 6/13/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 50.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 11-16-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 □ Dwg Rev: C □ Prog Rev: C □ 2-Deburr if necessary

304.063

B11-6-15

[Signature]

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-6-15

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

[Signature]

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____





NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Item ID:	D3537-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearpad					
Start Date:	6/13/2011	Start Qty:	50.00		Cust Item ID:	
Required Date:	6/17/2011	Req'd Qty:	50.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00							
Brake NC	Memo 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. □2- Identify as D3537-1	0.00				81			
140  Large Fab	Large Fab	0.00				81			
Large Fab	Memo Qty Description Batch □ A/R 2059B Hardcoat m118095 □ 1-Weld as per Dwg D3537 using Jig DT 8210 □ 2-Remove any weld that penetrated through Wearpad if necessary	0.00						11-06-29	JBL/EL
150  QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							

cents
81

W/O:		WORK ORDER CHANGES					
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Revision ID:

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Item Name: Wearpad

Start Date: 6/13/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M115128

3:45
320°F
4:15

Count
(751)

81 X Ø M-11/07/05

81 Ø 11-7-6.

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



Packaging

Identify as per dwg & Stock Location: *F-P17* 0.00

Memo

0.00

Packaging

81X *Q* *M-1* *11/07/06*

200



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/7/06 *J**mf*
11-07-06

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, June 13, 2011 1:32:12 PM

Page 1

Work Order ID: 70686

Parent Item: D3537-1

Parent Item Name: Wearpad



Start Date: 6/13/2011

Required Date: 6/17/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

119.1000

0.106

5.578947

91



B11-6-15

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

119.1

117275

4.3

117653

114.8

117653

(80)

W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

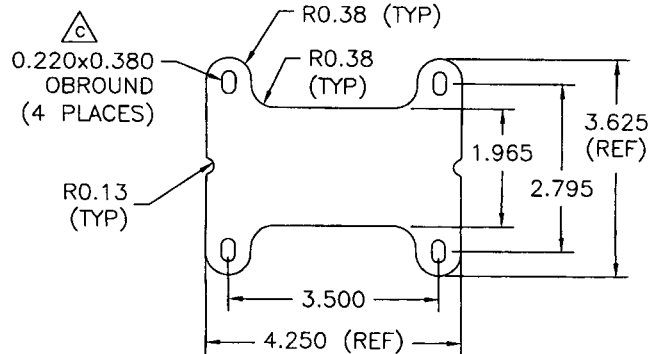
SUBJECT TO AMENDMENT

WITHOUT NOTICE

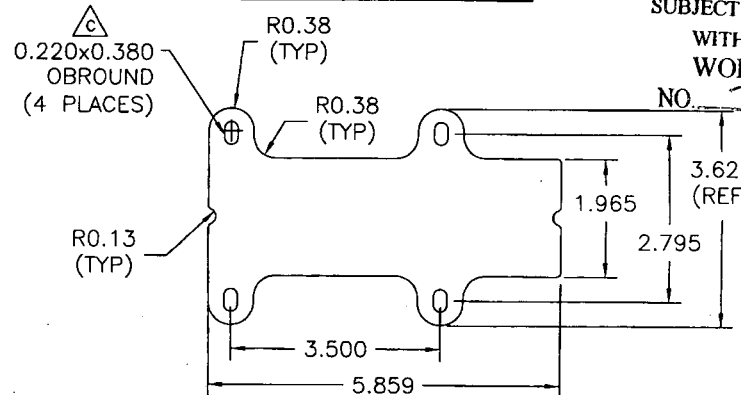
WORK ORDER

NO. 70684

D3537-1F FLAT PATTERN

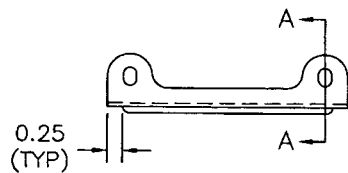


D3537-3F FLAT PATTERN



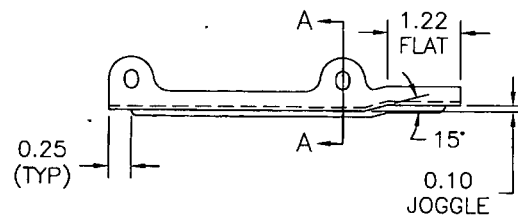
D3537-1 LONGITUDINAL BEND

(MADE FROM D3537-1F)



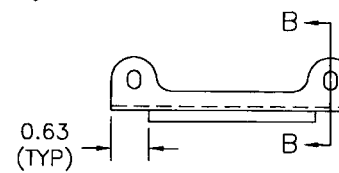
D3537-3 LONGITUDINAL BEND

(MADE FROM D3537-3F)

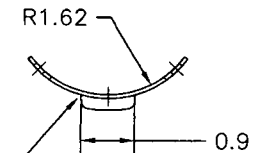


D3537-5 LONGITUDINAL BEND

(MADE FROM D3537-1F)

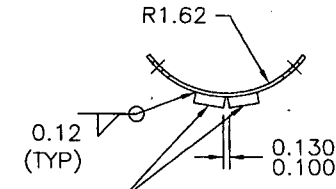


SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

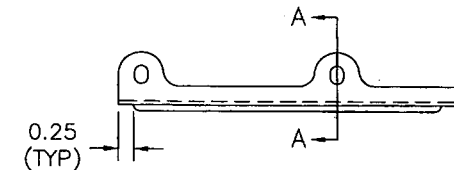
SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

D3537-7 LONGITUDINAL BEND

(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE
		1:2

RELEASED
07.05.08 PM
per ELN
962

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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